

Work Order ID 57945

April 21, 2010 8:41:09 AM



Page 1

Item ID: D3793-1

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 21/04/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 21/04/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

PM

Date: 10-4-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3793

Rev A

100



FLOW WATER JET

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3793

☐ Dwg Rev: A

☐ Prog Rev: A

☐ 2-

Deburr if necessary

OUT OF MATERIAL

10-4-21

(10)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

10-4-21

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

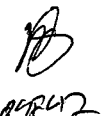
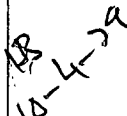

(19)

(10)

PAO →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3793-1 PAR #: _____ Fault Category: Small Fab/Water Jet NCR: (Yes) No DQA: 7/5 Date: 10/05/06
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 7/5 Date: 10/05/07

NCR: 57945		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/4/09	110	Found @ inspection qty +1 Part hole pattern is off. Sheet metal dim w/13. cutting R.C. process.	 09/04/09	Scrap + Destroy no replace Qty +1 (not enough mat.)	 10-4-09	8 10/04/09	 09/04/09	5 10/04/09

NOTE: Date & initial all entries

Work Order ID 57945

April 21, 2010 8:41:09 AM



Page 2

Item ID: D3793-1

Revision ID:

Item Name: Wearshoe

Start Date: 21/04/2010 Start Qty: 12.00

Required Date: 21/04/2010 Req'd Qty: 12.00

Reference:

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

0.00

Memo

0.00

1-Debur if necessary ☐ 2-Form on Brake as per Dwg D3793 using Jigs ☐ 3-Form
Joggle on brake using Jig as per Dwg D3793

SB 10/05/03

9

0

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

C 10/05/03

28

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

11/12/58

Memo

0.00

START TIME: 3:15pm
3:45pm FINISH TIME:

OVEN TEMPERATURE:

320

=> 10/05/04

9

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57945

April 21, 2010 8:41:09 AM



Page 3

Item ID: D3793-1

Revision ID:

Item Name: Wearshoe

Start Date: 21/04/2010 Start Qty: 12.00

Required Date: 21/04/2010 Req'd Qty: 12.00

Reference:

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

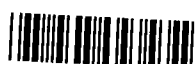
QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

7mm. 10/05/05 (9x)

170



Packaging

Packaging

Identify as per dwg & Stock Location: FP018

Memo

0.00

0.00

pk 10-5-5. x9

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/05/05

CL101514

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 21, 2010 8:41:14 AM

Page 1

Work Order ID: 57945

Parent Item: D3793-1

Parent Item Name: Wearshoe

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Start Date: 21/04/2010

Required Date: 21/04/2010

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	36.9800	7.4552	6.2125		

304/316 .040 Sheet

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

MAT20

112885

113062

36.98

5

31.98

1810-4-24

10

$$\begin{aligned} 112885 \times 3 &= 1.8637 \\ 113062 \times 7 &= 4.3488 \end{aligned}$$

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

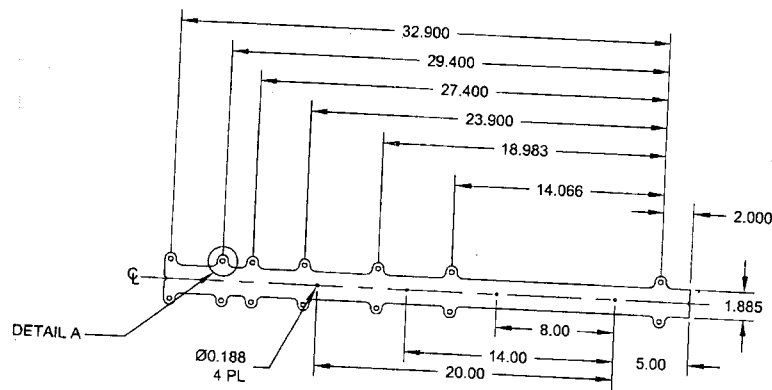
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

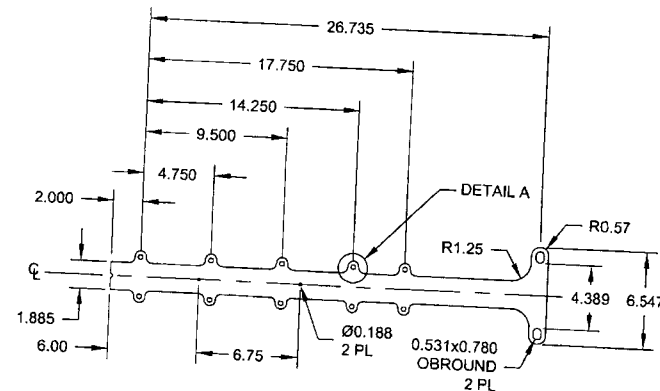
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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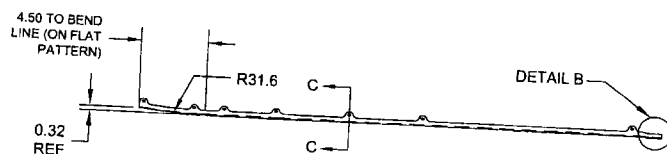
NOTE: Date & initial all entries



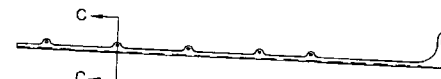
D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

RELEASED
28.05.23/18

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57945
PJ 10-4-21

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

A	NEW ISSUE	DESCRIPTION	PH	08.05.14
REV.			BY	DATE
DESIGN	PH			
DRAWN	PH			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.05.14			

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3793
TITLE WEARSHOE
SCALE NTS

REV. A
SHEET 1 OF 2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

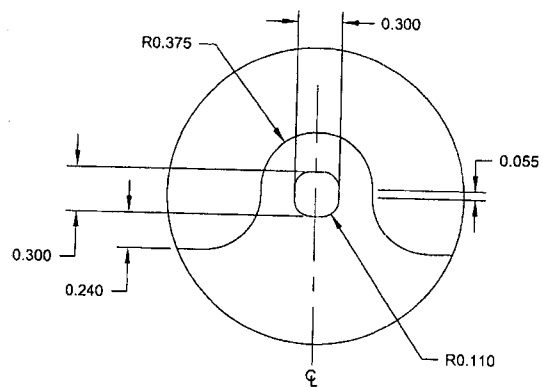
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

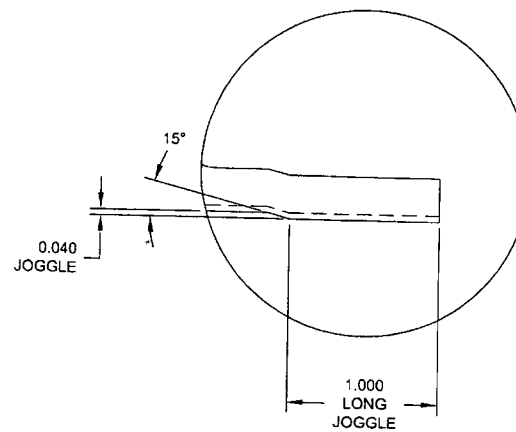
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

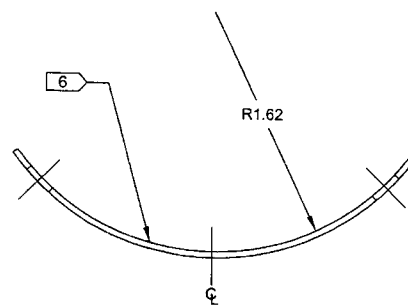
D



DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

W/O 57945

RELEASED
08-05-23 1/23

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	PH	D3793	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC	
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8 7 6 5 4 3 2 1

B

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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